

Date: Wednesday, 03/06/2009 10:48:48 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 48355					
Estimate Number	: 10534					
P.O. Number	:			Part Number	: D2574	
This Issue	: 03/06/2009		S.O. No. :	Drawing Number	: D2574 REV E	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: E	
Previous Run	: 47567			Material	:	
Written By	:			Due Date	: 30/06/2009	
Checked & Approved By	: <u>JUL 09.06.03</u>			Qty:	8 Um: Each	
Comment	: Est Rev: I As Per RevE 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>B46411</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>48355</u> Double check by: <u>MWF</u>	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	 <i>K.A. 09/06/11</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <i>K.A. 09/06/11</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	 <i>K.A. 09/06/11</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:48:49 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 48355

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

mf 09/06/11

(8)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL 09-06-11

(8)

7.0 POWDER COATING POWDER COATING



M111472

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 2:00pm

OVEN TEMPERATURE: 370°F

FINISH TIME: 2:30pm

09-06-15

XF

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Fx 09/06/15

(7)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



8X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 434

9/6/16

SD

10.0 QC21 FINAL INSPECTION/W/O RELEASE

09/06/17 d/f

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	4835
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.441	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.001	8.001	8.002		
F	0.490	0.510		0.500	0.500	0.494	0.498		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.503	0.502	0.502	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.573	0.570	0.570	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.127	0.127	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.251	0.251	0.251		
S	0.115	0.135		0.128	0.128	0.128	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.231	3.230	3.230	3.231		
V	0.230	0.250		0.238	0.238	0.238	0.240		
W	0.115	0.135		0.135	0.135	0.135	0.135		
X	0.307	0.312		.310	.310	.310	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.362	0.362	0.363	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.628	0.628	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.245	0.245	0.245		
AE	1.500	1.520		1.5125	1.5126	1.513	1.513		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.272	0.272	0.272	0.271		
AH	0.240	0.260		0.248	0.248	0.247	0.247		
AI	2.000	2.020		2.003	2.003	2.004	2.003		
AJ	0.023	0.043							

Accept/Reject

Measured by:	B. A	Audited by:	<i>JKL</i>
Date:	09/06/07	Date:	09/06/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JKL</i>	<i>JKL</i>

DART AEROSPACE LTD	Work Order:	CF8355
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

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				15	26	27	48		
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C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.002	8.001	8.001		
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H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.570	0.570	0.570	0.570		
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M	1.365	1.375		1.370	1.370	1.370	1.370		
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U	3.210	3.250		3.231	3.231	3.231	3.231		
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W	0.115	0.135		0.135	0.135	0.134	0.135		
X	0.307	0.312		0.309	0.312	0.312	0.312		
Y	0.760	0.765		0.761	0.760	0.761	0.760		
Z	0.352	0.372		0.362	0.362	0.362	0.362		
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AE	1.500	1.520		1.513	1.5134	1.5134	1.5136		
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AG	0.240	0.280		0.272	0.272	0.272	0.272		
AH	0.240	0.260		0.247	0.247	0.247	0.247		
AI	2.000	2.020		2.003	2.0032	2.0032	2.0034		
AJ	0.023	0.043							
Accept/Reject									

Measured by:	J.A	Audited by:	JKL
Date:	09/06/08	Date:	09/06/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JKL

